

Work Order ID 80799

February-29-12 9:45:00 AM

Must ship March 6

80799

Page 1

Item ID: D3319-7

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Wearplate

Stop ***NS2***

Start Date: 2/29/12 Start Qty: 4.00

4

Cust Item ID:

Required Date: 3/06/12 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: *u*

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3319

Rev B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3319 Dwg Rev: B Prog Rev: B 2-
Deburr if necessary

1010 050

B 12-2-29

(4)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B 12-2-29

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

Sizlozhs

(x4)

Work Order ID 80799

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February-29-12 9:45:00 AM

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Item Name: Wearplate

Start Date: 2/29/12 Start Qty: 4.00 *4*

Cust Item ID:

Required Date: 3/06/12 Req'd Qty: 4.00 *4*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

190

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

190

Powdercoat

Memo

0.00

Powder Coating

START TIME: 11h20 OVEN TEMPERATURE:

11h50 FINISH TIME: 320°F

m 118 489.

4 8 50/11/12/03/05

200

QC3- Inspect Part Finish

0.00

200

QC

Memo

0.00

Quality Control

4 BR 12 3-5.

210

Packaging

0.00

210

Packaging

Memo

0.00

Packaging

Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3319-7, B/N: BXXXXX For Product Eligibility see PDA05-18 and Stock Location: 497

12/3/50 (4)

Work Order ID 80799

February-29-12 9:45:00 AM

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Item ID: D3319-7

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate

Start Date: 2/29/12 Start Qty: 4.00

4

Cust Item ID:

Required Date: 3/06/12 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

MLJ 12/03/05

C2 12/03/05

Picklist Print

February-29-12 9:44:59 AM

Page 1

Work Order ID: 80799

Parent Item: D3319-7

Parent Item Name: Wearplate

Start Date: 2/29/12

Required Date: 3/06/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: A05.05.12New issue KJ/JLM
IPP Rev:B Now on Waterjet 07-06-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S18GA		Purchased	No			110	sf	204.8000	0.548	2.3073684			
1010/1025 SHEET .048													

1B12-2-29

Location

Loc Qty

Loc Code

MAT019

204.8

116268

10

117806

194.8

117806

④

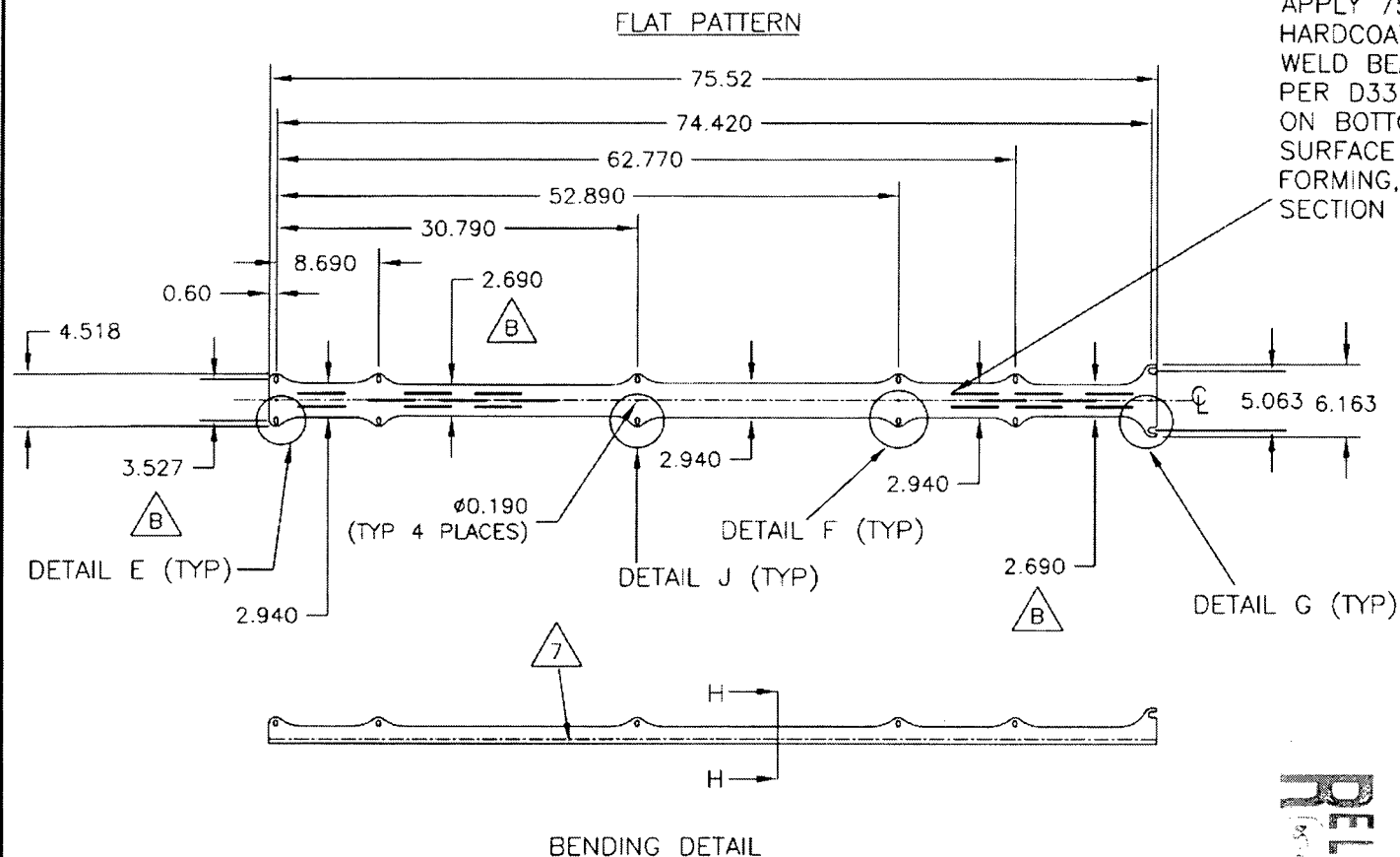
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- 1) MATERIAL: AS9100 ~~AS1010~~ -1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

CHECKED <i>PH</i>		APPROVED <i>PH</i>		DRAWING NO. D3319	REV. B SHEET 1 OF 5
DATE 05.06.06		TITLE WEARPLATE			
A	04.09.24	NEW ISSUE			
B	05.06.06	WIDEN HOLES,REDUCE WIDTH		-3/-5/-7	

DAFT



APPLY 7560
HARDCOAT
WELD BEADS
PER D3319-3T1
ON BOTTOM
SURFACE AFTER
FORMING, SEE
SECTION H-H

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. B
05.06.06	D3319	SHEET 2 OF 5
	WEARPLATE	SCALE
		1:15

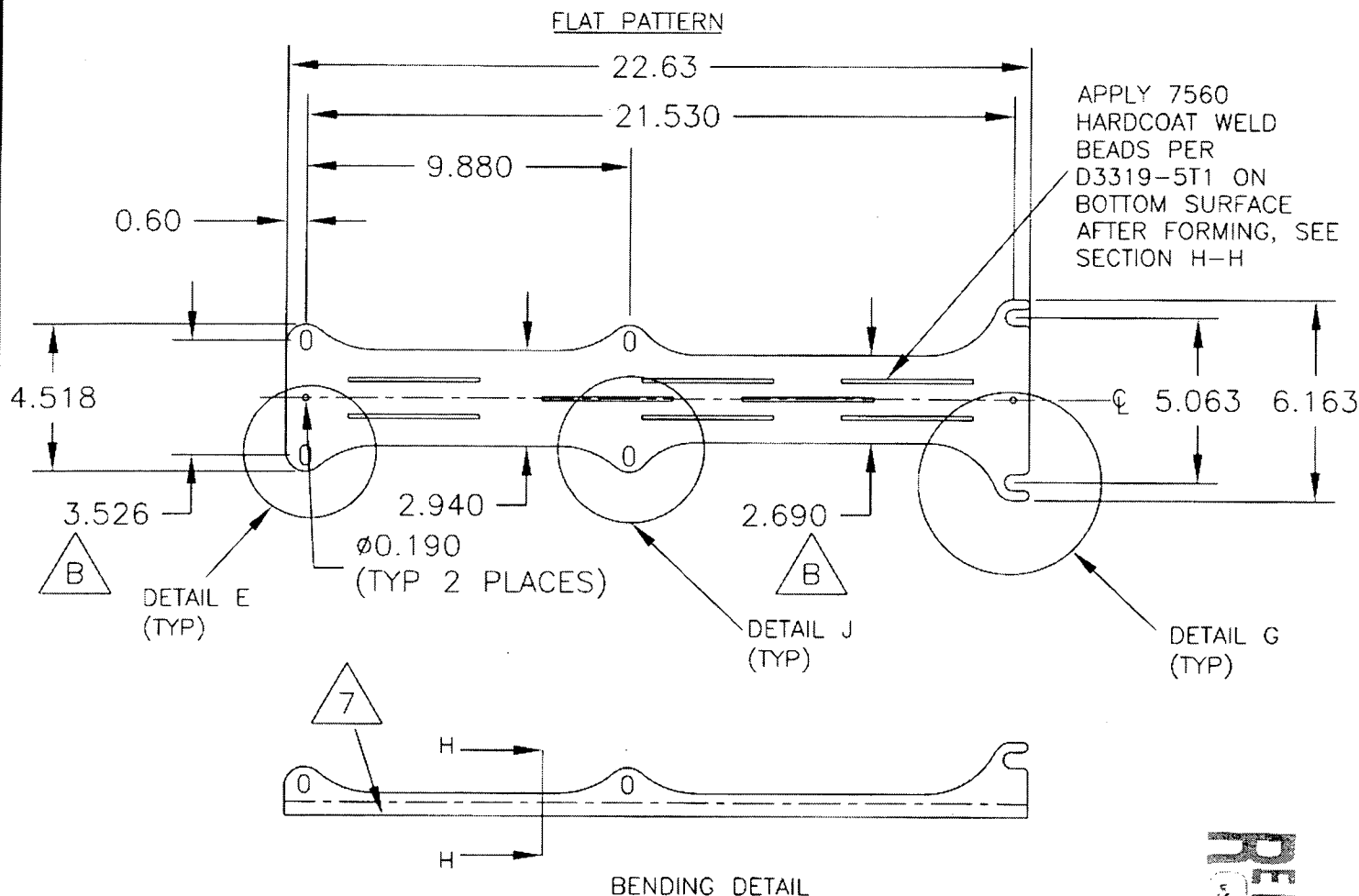
D3319-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

RELEASED

DART

DESIGN	D31	DRAWN BY	DART AEROSPACE LTD
CHECKED	11	APPROVED	11
DATE	05.06.06	DRAWING NO.	D3319
		TITLE	WEARPLATE
		SCALE	1:5
		SHEET 3 OF 5	REV. B
			HAWKESBURY, ONTARIO, CANADA



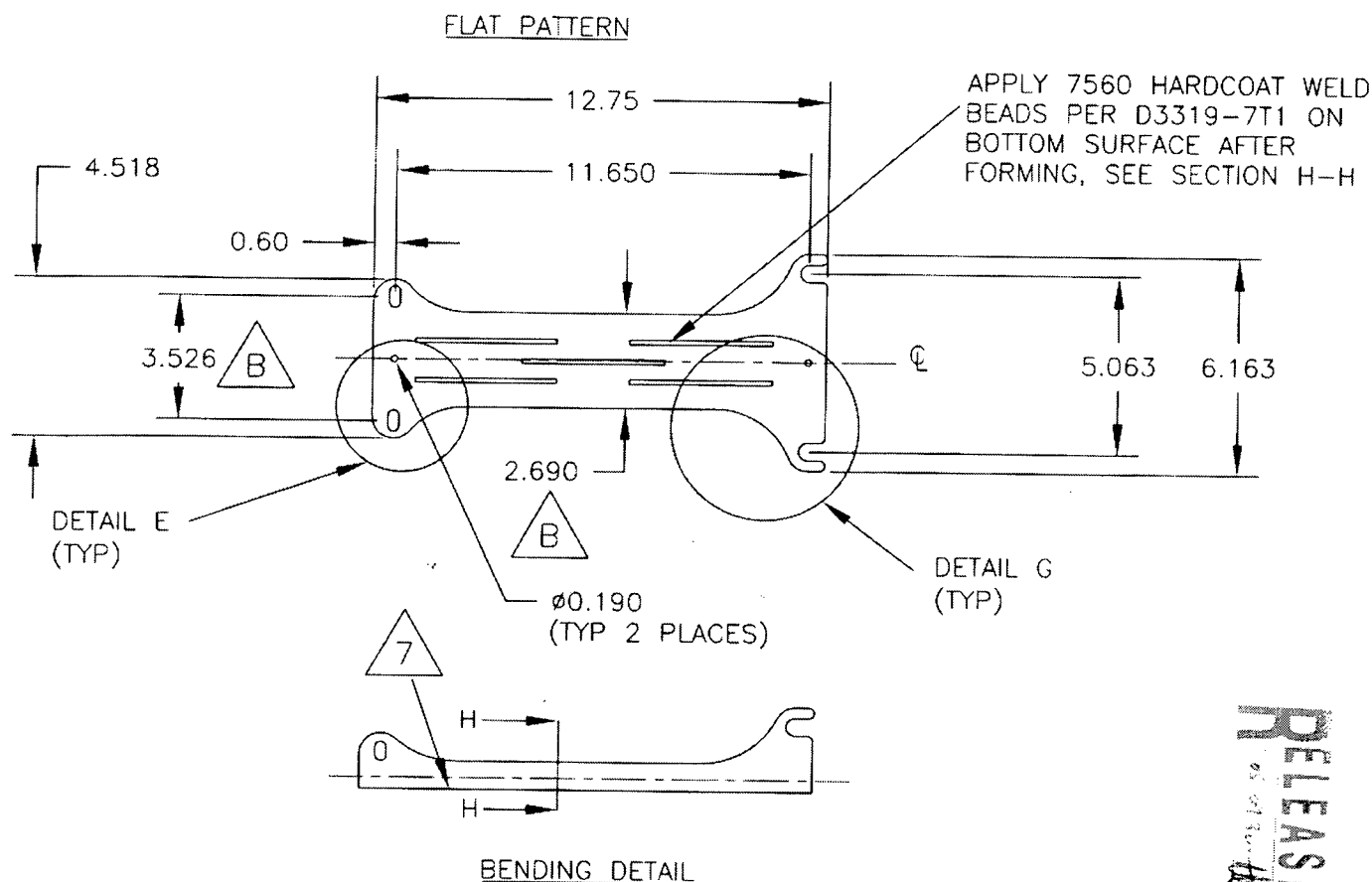
RELEASED
15-07-30

D3319-5 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"



DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD
CHECKED	PH	APPROVED	PH	HAWKESBURY, ONTARIO, CANADA
DATE	05.06.06	DRAWING NO.	D3319	REV. B
		TITLE	WEARPLATE	SHEET 4 OF 5
		SCALE	1:5	



RELEASED

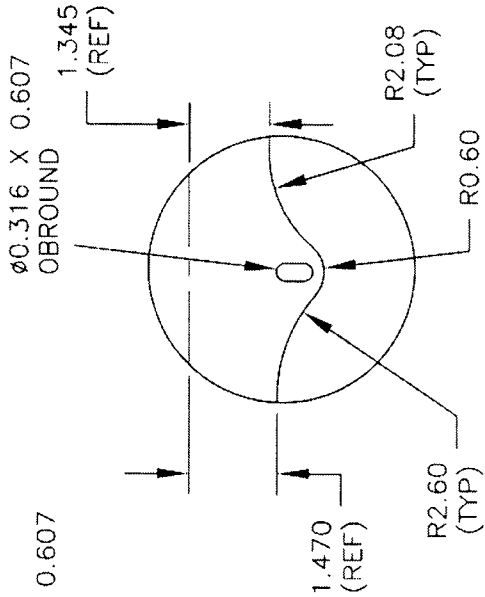
D3319-7 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

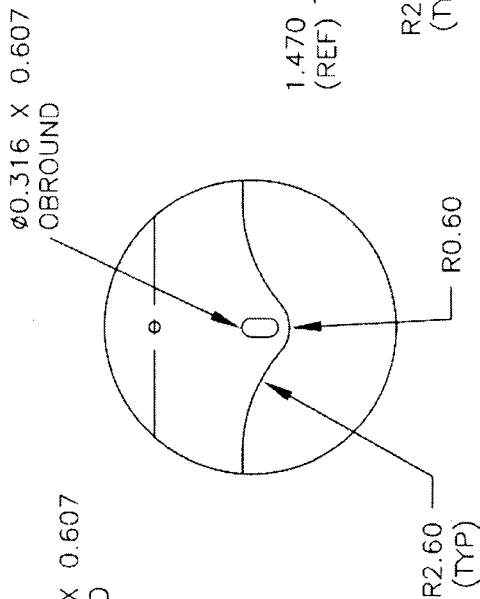


DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3319	REV. B SHEET 5 OF 5
DATE 05.06.06		TITLE WEARPLATE	SCALE 1:3

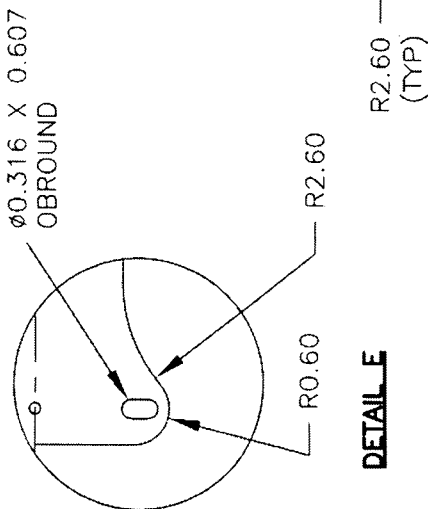
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05-09-30



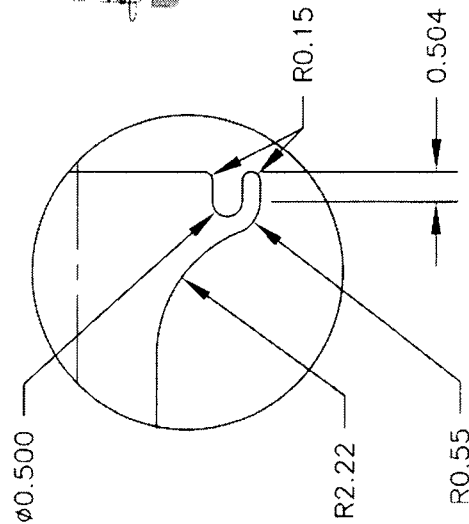
DETAIL J



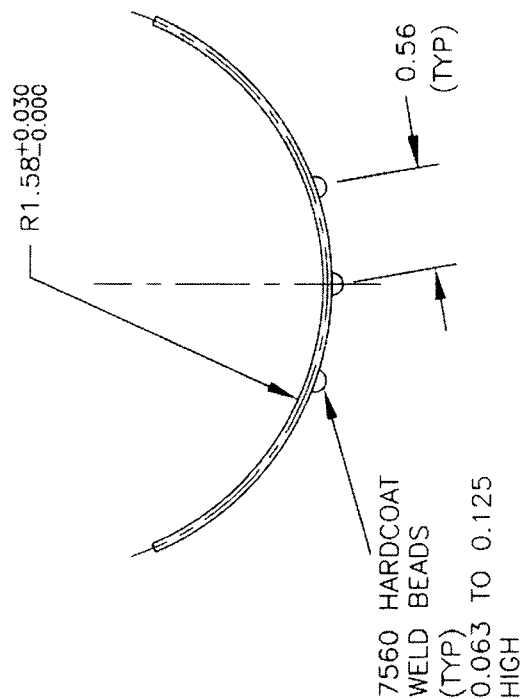
DETAIL F



DETAIL E



DETAIL G



SECTION H-H
(SCALE 1:1)

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